



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE703A94-1130-01-01

Job Sheet 173922



Part No: RBE703A94-1130-01-01

Job Qty: 6 ea

Part Name: Immobilizing Clip Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev.A 17.08.08 New issue DP Verify DD/IPP Rev B 17.11.30 DWG
Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/13/18	0.00	0.00	Start Up Small Fab-4		MCC
120	Small Fab	6 pcs		4/14/18	0.00	6.00	Small Fab-3		MCC DAS
130	QC	6 pcs		4/14/18	0.00	0.00	QC5		38
140	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging3-1		MCC 9-89
150	QC21-SA	6 Ea		4/14/18	0.00	0.00	QC21		

Part Op Descriptions: 120 - Assemble as per DWG. Sheet 2

DAS
21
9-80
JUL 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
64 90353A217	Pan Head Machine Screw M4 x 0.7mm x 20mm	12 Ea (2 ea)	90-Start up Operation	FM138414-5
67 91166A270	Washer, M8	24 Ea (4 ea)	90-Start up Operation	FM138414-10
51 91595A112	Dowel Pin ØM3 x 12mm	12 Ea (2 ea)	90-Start up Operation	FM138414-1
40 98296A881	Roll Pin Ø1/8 X 3/4	12 Ea (2 ea)	90-Start up Operation	FM138414-33
133 RBE703A94-1130-01-03	Bottom Fixture 1	6 Ea (1 ea)	90-Start up Operation	50891011
133 RBE703A94-1130-01-05	Fixture Handle	12 Ea (2 ea)	90-Start up Operation	5077431
133 RBE703A94-1130-01-07	Handle Stud	12 Ea (2 ea)	90-Start up Operation	5089852
133 RBE703A94-1130-01-09	Bottom Fixture 2	6 Ea (1 ea)	90-Start up Operation	5079747
131 RBE703A94-1130-01-11	Angle Indicator	6 Ea (1 ea)	90-Start up Operation	5081684
131 RBE703A94-1130-01-13	Compression Spring Ø1.25mm x 11.25mm OD x 44.5mm	12 Ea (2 ea)	90-Start up Operation	5067110

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90353A217	12	98	0
	91166A270	24	75	0
	91595A112	12	45	0
	98296A881	12	248	0
	RBE703A94-1130-01-03	6	0	0
	RBE703A94-1130-01-05	12	0	0
	RBE703A94-1130-01-07	12	0	0
	RBE703A94-1130-01-09	6	0	0
	RBE703A94-1130-01-11	6	0	0
	RBE703A94-1130-01-13	12	12	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																			
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																					
Date : _____	Step #: _____	Uart Aerospace Ltd. 1270 Aberdeen Street Newkensbury, ON K6A 1K7 CANADA S1S 6S2 - 5200 TEL: 519 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/12/18 Container No: S091011 Part: FIB703A94 - 1130 - 01 - 01 Job No: 173922 Serial No/Batch: S091011 Revision: K Inspector: Exp Date: Instructions:																																																																																																																					
Description Work																																																																																																																							
MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																																							
Root Cause <table style="width:100%;"> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>		Environment ☐	No Re-verification ☐					Design ☐	Operator ☐					Doc/Data ☐	Offset/Setup ☐					Equip/Tooling ☐	Supplier ☐					Handling/Pre ☐	Training ☐					Material ☐	Use for Testing ☐					Internal Transport ☐	Poor Information ☐					Tribal Knowledge ☐	Rushing ☐					LOA ☐	Product Improvement ☐					Substation ☐	Process Improvement ☐					Past Expiry Date ☐	Manufacturing Process ☐					Misidentified ☐	Past Due ☐					<table style="width:100%;"> <tr> <td style="width:15%;"></td> <td style="width:15%;">Crimp/Kink/Ripple/Wave ☐</td> <td style="width:15%;">Inspection Incomplete/Unqualified ☐</td> <td style="width:15%;">Weld ☐</td> <td style="width:15%;"></td> <td style="width:15%;"></td> </tr> <tr> <td></td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Wrong Stock Pulled ☐</td> <td></td> <td></td> </tr> <tr> <td></td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Out of Sequence ☐</td> <td></td> <td></td> </tr> <tr> <td></td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Off-set ☐</td> <td></td> <td></td> </tr> <tr> <td></td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Mislabeled ☐</td> <td></td> <td></td> </tr> <tr> <td></td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Fit/Function ☐</td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td>Misaligned/off center ☐</td> <td></td> <td></td> </tr> </table>					Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Weld ☐				Cuffs ☐	Contamination ☐	Wrong Stock Pulled ☐				Crushing ☐	Countersink ☐	Out of Sequence ☐				Heat Treat ☐	Cut Too Short ☐	Off-set ☐				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Mislabeled ☐				Marks/Chatter ☐	Drill Holes ☐	Fit/Function ☐						Misaligned/off center ☐		
Environment ☐	No Re-verification ☐																																																																																																																						
Design ☐	Operator ☐																																																																																																																						
Doc/Data ☐	Offset/Setup ☐																																																																																																																						
Equip/Tooling ☐	Supplier ☐																																																																																																																						
Handling/Pre ☐	Training ☐																																																																																																																						
Material ☐	Use for Testing ☐																																																																																																																						
Internal Transport ☐	Poor Information ☐																																																																																																																						
Tribal Knowledge ☐	Rushing ☐																																																																																																																						
LOA ☐	Product Improvement ☐																																																																																																																						
Substation ☐	Process Improvement ☐																																																																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																																																																						
Misidentified ☐	Past Due ☐																																																																																																																						
	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Weld ☐																																																																																																																				
	Cuffs ☐	Contamination ☐	Wrong Stock Pulled ☐																																																																																																																				
	Crushing ☐	Countersink ☐	Out of Sequence ☐																																																																																																																				
	Heat Treat ☐	Cut Too Short ☐	Off-set ☐																																																																																																																				
	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Mislabeled ☐																																																																																																																				
	Marks/Chatter ☐	Drill Holes ☐	Fit/Function ☐																																																																																																																				
			Misaligned/off center ☐																																																																																																																				
OTHER : _____		<table style="width:100%;"> <tr> <td style="width:15%;"></td> <td style="width:15%;">Positioned Wrong ☐</td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> </tr> <tr> <td></td> <td>Outside Dimensions ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Over/Under tolerance ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Part Incorrect ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Part Lost/Missing ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Part Moved ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Drawing ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Finish ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Misread ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Turning Sequence ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>					Positioned Wrong ☐						Outside Dimensions ☐						Over/Under tolerance ☐						Part Incorrect ☐						Part Lost/Missing ☐						Part Moved ☐						Drawing ☐						Finish ☐						Misread ☐						Turning Sequence ☐																																																										
	Positioned Wrong ☐																																																																																																																						
	Outside Dimensions ☐																																																																																																																						
	Over/Under tolerance ☐																																																																																																																						
	Part Incorrect ☐																																																																																																																						
	Part Lost/Missing ☐																																																																																																																						
	Part Moved ☐																																																																																																																						
	Drawing ☐																																																																																																																						
	Finish ☐																																																																																																																						
	Misread ☐																																																																																																																						
	Turning Sequence ☐																																																																																																																						

Part Specifications

Specifications could not be found.

Plex 3/8/18 8:09 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																
Description Work Order Deviation				Disposition																																																																			
Root Cause <table style="width:100%; border: none;"> <tr><td style="width:15%;">Environment ☐</td><td style="width:15%;">No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Pressure/Forced ☐</td> <td style="width:15%;">Temperature/Cure ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>						Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																						
Design ☐	Operator ☐																																																																						
Doc/Data ☐	Offset/Setup ☐																																																																						
Equip/Tooling ☐	Supplier ☐																																																																						
Handling/Pre ☐	Training ☐																																																																						
Material ☐	Use for Testing ☐																																																																						
Internal Transport ☐	Poor Information ☐																																																																						
Tribal Knowledge ☐	Rushing ☐																																																																						
LOA ☐	Product Improvement ☐																																																																						
Substation ☐	Process Improvement ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
		OTHER : _____																																																																					